to Rev D Dwg only 5/14/27

PRELIM ~~ISSUE~~

Work Order ID 119733

May-20-14 12:46:15 PM

119733

Item ID: D2267-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: ~~PRELIM~~ Rev D **Stop** *NS2*

Item Name: L Bracket

Start Date: 5/20/14 **Start Qty:** 2.00 *2* **Cust Item ID:**

Required Date: 5/20/14 **Req'd Qty:** 2.00 *2* **Customer:**

Reference:

Approvals: **Process Plan:** ML5 **Date:** 14-05-20 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2267	~~pdf~~ Rev D 5/14/27								
100	~~STEAR~~	0.00							
100						2	2		JM14-06-4
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2267 Dwg Rev:_____ Prog Rev:_____								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						2	2		JM14-06-4
QC	**Memo**	0.00							
Quality Control									

PTO → last page

Item ID: D2267-1
Revision ID: PRELIM
Item Name: L Bracket
Start Date: 5/20/14 **Start Qty:** 2.00 *2*
Required Date: 5/20/14 **Req'd Qty:** 2.00 *2*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				2			
120									
QC	**Memo**	0.00							
Quality Control									
130	Bend as per dwg	0.00							
130	Small Fab								
Brake NC	**Memo**	0.00				2			
Brake NC									
140	QC5- Inspect part completeness to step on W/O	0.00				2			
140									
QC	**Memo**	0.00							
Quality Control									

DAS 27 9-89 — 14/6/14
DAS 30 9-89
DAS 27 9-89 — 14/6/14

Inspect as per Rev Pd1
Inspect as per Pd1
14/6/14

Item ID: D2267-1
Revision ID: PRELIM
Item Name: L Bracket
Start Date: 5/20/14 **Start Qty:** 2.00 *2*
Required Date: 5/20/14 **Req'd Qty:** 2.00 *2*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location:_____	0.00							
150						SHIPPED	TO	DAVID	S.
Packaging	**Memo**	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160						14/9/9			
QC	**Memo**	0.00							
Quality Control									

MF 14-6-6

OSITIVE RECALL
EFFECTIVE 140520 AUTH
RELEASED S DATE 14/05/27
to Rev D Dwg only

Picklist Print

May-20-14 12:46:18 PM

Work Order ID: 119733 *119733*

Parent Item: D2267-1 *D2267-1*

Parent Item Name: L Bracket

Start Date: 5/20/14 **Required Date:** 5/20/14

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP REV:A 14.05.13 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA *M304S16GA* 304/316 Sheet .063		Purchased	No				sf	286.1670	**	(1)		JM 14-06-4	

Location	Loc Qty	Loc Code	
MAT020	286.167		
M127821	75.567		
M128423	1.2		
M129192	209.4		129192

DART AEROSPACE LTD	Work Order:	119733
Description: Bracket	Part Number:	102267-1
Inspection Dwg: 102267 Rev: 01		Page 1 of 1

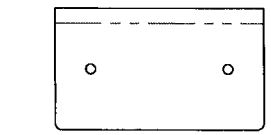
FIRST ARTICLE INSPECTION CHECKLIST

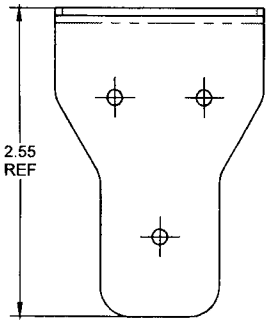
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.080"	+0.004-0.001	0.080"	–		V	Jmc5
Ø 0.129"	+0.005-0.001	0.129"	–		V	
0.750"	+/-0.010"	0.754"	–		V	
1.150"	"	1.151"	–		V	
0.500"	"	0.503"	–		V	
1.00"	"	1.002"	–		V	
1.150"	"	1.152"	–		V	
1.64"	+/-0.030"	1.64"	–		V	
1.75"	"	1.754"	–		V	
3.45"	"	3.449"	–		V	
1.64"	"	1.64"	–		V	
0.063"	+/-0.010"	0.056"	–			

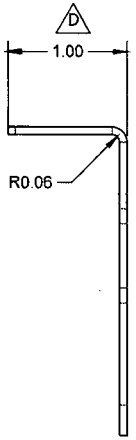
Measured by:	Jm	Audited by:	27 -89	Preliminary Approval:	
Date:	14-06-4	Date:	14/6/4	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

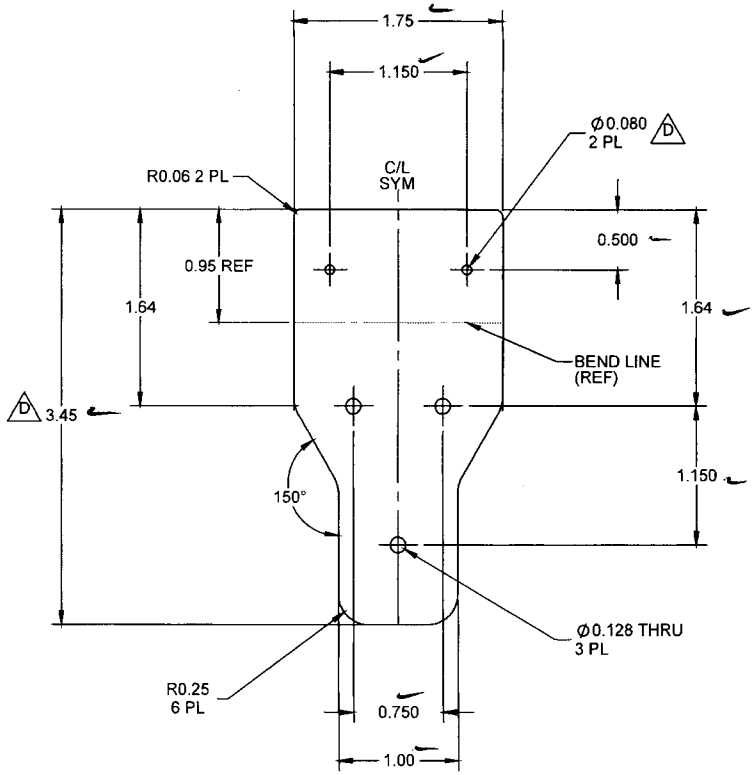






D2267-1 L BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
No. 119733 MC5
14 05 20



D2267-1F FLAT PATTERN

PRELIMINARY

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 16 GAUGE 0.063" THICK, (REF DART SPEC M304S16GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.09 lbs

REV.	DESCRIPTION	BY	DATE
D	AISI 304 SS WAS 2024-T3 ALUM., 1.00 WAS 0.75, 3.45 WAS 3.194, Ø0.08 2 PL WAS Ø0.128	DB	14.03.11
C	R0.13 WAS R0.094; ADDED FLAT PATTERN	RF	01.06.14
B	REDRAWN	RF	96.06.04
A	NEW ISSUE	RF	94.09.15

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO. D2267	REV. D
MFG. APPR.	JLM		SHEET 1 OF 1
APPROVED	MP	TITLE L BRACKET	SCALE NTS
DE APPR.	DS		
DATE	14.03.11		

APPROVED

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DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: 119733

Part No. D2267-1

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☒
Use-as-is	☐
Suspected Unapproved	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☒
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐
Large Fab	☐	Composite	☐	Supplier	☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐	14-06-4	100	2	Material wrong thickness Operator error/ operation done verify Mat.	S Q32012 14/07/08	Scrap + destroy Use correct MATL M304S16GA	JH 14-06-4	S 14/07/08	S 14/07/08 Q32012
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☒									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐	Bending
☐	Centre Not Concentric
☐	Cracks
☐	Crimp/Kink/Ripple/Wave
☐	Cuffs
☐	Crushing
☐	Heat Treat
☐	Inspection Strip in Tube
☐	Marks/Chatter
☐	Turning Sequence
☐	Wave/Twist in Tube

General

☐	Bend
☐	BOM/Route
☐	Broken/Damage/Defect
☐	Burrs
☐	Contamination
☐	Countersink
☐	Cut Too Short
☐	Drawing
☐	Drill Holes
☐	Finish
☐	Fit/Function
☐	Folio/Program
☐	Grain
☐	Hardware
☐	Inspection Incomplete/Unqualified
☐	Instructions Incomplete/Unclear
☐	Misaligned/off center
☐	Mislabeled
☐	Misread
☐	Off-set
☐	Out of Calibration
☐	Out of Sequence
☐	Outside Dimensions
☐	Over/Under tolerance
☐	Part Incorrect
☐	Part Lost/Missing
☐	Part Moved
☐	Positioned Wrong
☐	Power Loss/Surge
☐	Pressure/Forced
☐	Set-up
☐	Temperature/Cure
☐	Weld
☒	Wrong Stock Pulled
☐	Other

DART AEROSPACE LTD

Description: L Bracket Work Order: 119733

Inspection Drawing: D2267 Rev: Pd1 Part Number: D2267-1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/- .030	.999	✓		V	SD-11
2.55	+/- .030	2.554	✓		V	SD-11

Measured by: DAS 30 9-89	Checked By: DAS 36 9-89	QC inspector: DAS 27 9-89	Engineering Approval (*if necessary*)
Date 14/06/05	Date 14/06/05	Date 14/6/5	Date

Purchase Order Receipt Listing

Friday, May 16, 2014 9:51:45 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO23746 Receipt Dates from 5/16/2014 to 5/16/2014 All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		**VC-COP001**	**Thyssenkrupp Materials CA Ltd**								
PO23746	1		M304516GA 3047516 Sheet 063 m129192	sf sf	4/17/2014 224.0000	5/16/2014 DESJ02	224.0000	$3.90 $872.92	0.0000 0.0000	0 0	$872.92
CAD	No										
	6		71401-45		4/17/2014	5/16/2014	1.0000	$0.00	0.0000	0	$0.00
	No		Procurement Quality Clauses m129192		1.0000	DESJ02		$0.00	0.0000	0	

Total Received Quantity:	225.0000
Total Qty to Inspect (PO U/M):	0.0000
Total Reject Quantity:	0.0000
Total Receipt Value:	$872.93
Total Balance Due Quantity:	0.0000

B I L L O F L A D I N G

No: PEC 877147

Ship From:
THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 905-738-9033

Ship Date 13May14 at 9:27 From PFW
Probill
Via VIM DELIVERY
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DAIRT AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

Ship To: (1)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
Tel: 613-632-9577 Fax: 613-632-1053

==========

B I L L O F L A D I N G

1) Our Order PEC-671461- 1 Your PO # 23746

STAINLESS STEEL SHEET 304-2B
.0600 Nom X 48.0000" X 96.0000"

MTR

Heat Number	Tag No	Quantity	PCS	Wt LBS
884227	291595	224.00 SFT	7	539

	Tags	PCS	LBS
TOTAL:	1	7	539

MILL TEST REPORTS, PACKING SLIPS ARE TO SENT
WITH MATERIAL AND FAXED TO THE CUSTOMER PRIOR
TO SHIPPING.
ATTN: CHANTAL/LINDA
** ALL PACKING SLIPS MUST HAVE THE HEAT NUMBER **
** REFERENCED ON IT **

BACK ORDER FROM OUR PREVIOUS B/L# 872577
TOTAL 1 SKID GW. 604 LBS

*CUSTOMER PICK-UP HRS AT THYSSENKRUPP MATERIALS NA
CONCORD, ONT.* *** 9:00 AM TO 4:00 PM ***
**** TEL. 800-926-2600 ****

* WE STOCK STAINLESS STEEL *
* PLEASE LET US QUOTE YOUR NEXT REQUIREMENT *

***PLEASE NOTE A $25.00 ENERGY SURCHARGE WILL BE
ADDED TO EVERY ORDER.***

Page: 1 Last

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE RAPPORTÉES IMMÉDIATEMENT.
ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY
RETOUR DE MARCHANDISES AVEC NOTRE NUMERO D'APPROBATION SEULEMENT.
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

REÇU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION

DATE

84566

Rec 258135-1

CUST 84224 PN

Herstellerwerk / Manufacturer's works / Usine productrice

(EBK 2??)

outokumpu

Art der Prüfbescheinigung / Type of inspection document / Type de document

ABNAHMEPRUEFZEUGNIS
INSPECTION CERTIFICATE
CERTIFICAT DE RECEPTION
nach / according to / suivant
EN 10204-3.1

Bescheinigungs-Dokument-Nummer / Document number / Numéro de document
1000496333 /

Seite / Page / Page
1 / 1

Oberschlesienstrasse 16, 47807 Krefeld

OUTOKUMPU STAINLESS USA, LLC
1 ThyssenKrupp Drive
CALVERT, ALABAMA AL 36513-1300
USA

Besteller/Empfänger / Customer/Consignee / Acheteur/Destinataire
OUTOKUMPU STAINLESS USA, LLC,Calvert, Ala

Kundenbestellnr. / Customer's order number / Numéro de la commande du client
51004304

Werksauftragsnr. / Manufacturer's works order no. / N° de la commande de l'usine productrice
900453432 / 001

Lieferanzeige Nr. / Delivery Note No. / Avis d'expédition N°
87627406 / 010

Erzeugnis / Product / Produit
BLECH/SHEET/TOLE

Lieferbedingungen / Terms of delivery / Conditions de livraison
ASTM A 666
SAE AMS 5513 J
ASTM A 240/A 240M
ASME SA 240/SA 240M Sec.II Part A Ed.2013

Stahlsorte und Gütegruppe / Steel grade and quality
Type 304

Kundenmaterial-Nr. / Customer's material number / N° de matière du client	Maße des Erzeugnisses (Dicke / Breite / Länge) / Product dimensions (Thickness / Width / Length) / Dimensions du produit (Epaisseur / Largeur / longeur)	Herstellungsart / Steelmaking process / Mode d'élabor.	Ausführung / Finish / Fini
P003389	0.0579 inch x 48.0000 inch x 96.0000 inch	AOD	IIIc / 2B

Paket-Nr. / Packing-no / N° Palette	Stückzahl / No of pieces / N° de pièces	Ist-Gewicht / Actual weight / Masse effective	Ident.-Nr. Erzeugnis / Ident.-No of product / Ident. N° du produit	Schmelzennr. / Cast number / Numéro de coulée	Proben-Id. / Sample Id. / Empl.du prélèvement	Proben-Id. / Sample Id. / Empl.du prélèvement
8702379	52	4.017 lbs	278676	884227	1002875783	1002875784
8702380	52	3.995 lbs	278676	884227	1002875783	1002875784
	104	8.012 lbs				

Chemische Zusammensetzung / Chemical composition

Schmelzennummer	% C	% Si	% Mn	% P	% S	% Cr	% Ni	% N	% Mo	% Cu
884227	0.033	0.38	1.28	0.027	0.0040	18.13	8.50	0.040	0.20	0.44

Prüflos/Inspection lot / Lot de contrôle
Probenid./-Lage / Sample Id./-Position / Ident./empl.du prélèvement: QUER

	YS0,2% PSI	YS1,0 PSI	TS PSI	El.A2" %	HV HV	HRB HRB
1002875783	43365	47135	89485	58.8	173	80.0
1002875784	43655	47280	89485	59.5	170	80.0

Bestand g. interkrist. Korros. / Res. to intercryst. corros. / Résistant à la corros. intercrist.: EN ISO 3651-2 I.O.

ASTM A 262 PRACTICE E I.O.

Metallische Oberfläche / Dimensionale Surface / Dimensions de surface: I.O.

Verwechslungsprüfung (Spektralanalyse) / Test of identity (spectrum analysis) / Contrôle d'identification (analyse spectrale):

WAERMEBEHANDLUNG : 1050 GRAD C / LUFT

TRAITEMENT TERMIQUE : 1050 GRAD C / AIR

HEAT - TREATMENT : 1050 DEGREE / AIR

Aussteller der Bescheinigung / Originator of the document / Auteur du document

Outokumpu Nirosta GmbH
Dieses Zeugnis wurde
maschinell erstellt
Werk Krefeld

Abnahmebeauftragter / Inspector / Expert
Ulrich Wienert
Tel.: 49-2151-83-3142
Fax: 49-2151-83-4106
Certificates.Nirosta@outokumpu.com

Stempel des (der) Abnahmebeauftragten / Receiving agent's stamp / Poinçon de l'agent réceptionnaire: QA

Daten der Ausstellung und Bestätigung / Date of issue and validation / date d'émission et validation: 15.11.2013

DART AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23746

Purchase Order Date 4/10/2014
PO Print Date 4/10/2014

Order From : VC-COP001

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL"A"
TORONTO, ON M5W 5V8
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

14/04/10

Contact Name		**Buyer**	Chantal Lavoie
Vendor Phone	905 669 9444	**Customer POID**	
		Customer Tax #	10127-2607
Ship To Contact		**Terms**	Net 30
Ship To Phone		**Currency**	CAD
Ship Via:	VENDOR'S TRUCK	**FOB**	FCA – (Free Carrier)
Ship Acct:			

Line Nbr	Reference / Vendor Part Number / Line Comments / Delivery Comments	Description/ Mfg ID	Req Date/ Taxable / Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended
1	M304S16GA	304/316 Sheet .063	4/17/2014 Yes 4/17/2014		224.00 sf	$4.27	
	[redacted] MATERIAL; AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240						
						Line Total:	$95[illegible]
2	M304S18GA	304/316 .050 Sheet	4/17/2014 Yes 4/17/2014		224.00 sf	$3.45	[illegible]
	MATERIAL; AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240						
						Line Total:	$77[illegible]

PO Instructions: quotation:
no: pec st-0670569

Note:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23746

Purchase Order Date 4/10/2014
PO Print Date 4/10/2014

Order From : VC-COP001

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL"A"
TORONTO, ON M5W 5V8
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name		**Buyer**	Chantal Lavoie		
Vendor Phone	905 669 9444	**Customer POID**			
		Customer Tax #	10127-2607		
Ship To Contact		**Terms**	Net 30		
Ship To Phone		**Currency**	CAD		
Ship Via:	VENDOR'S TRUCK	**FOB**	FCA – (Free Carrier)		
Ship Acct:					

3	M2024T3S.020	Alum. sheet .020	4/17/2014 Yes 4/17/2014	48.00 sf	✓	$4.33	$2

MATERIAL: 2024-T3 ALUMINUM SHEET
AS PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR
AMS 4037 OR ASTM B209

4/4/23 **Line Total:** $208.

4	M6061T6S.063	6061-T6 .063 Sheet	4/17/2014 Yes 4/17/2014	320.00 sf	✓	$3.31	$1,0

MATERIAL: 6061-T6/T62 ALUMINUM SHEET
AS PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209

Line Total: $1,0

5	M6061T6S.080	6061-T6 .080 Sheet	4/17/2014 Yes 4/17/2014	336.00 sf	✓	$4.13 ✓	$1,

MATERIAL: 6061-T6/T62 ALUMINUM SHEET
AS PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209

4/4/23 Rec 3-8

PO Instructions: quotation:
no: pec st-0670569

Note:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23746

Purchase Order Date 4/10/2014
PO Print Date 4/10/2014

Order From : VC-COP001

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL"A"
TORONTO, ON M5W 5V8
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905 669 9444

Ship To Contact
Ship To Phone
Ship Via: VENDOR'S TRUCK
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA – (Free Carrier)

Line Total: $1,380.00

6	71401-45	Procurement Quality Clauses	4/17/2014	1.00	$0.00
			No		
			4/17/2014		

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality document

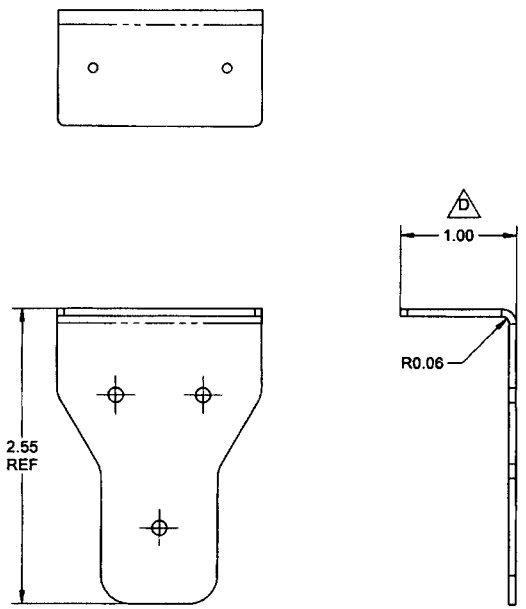
Line Total: $0.00

PO Total: $4,385.00

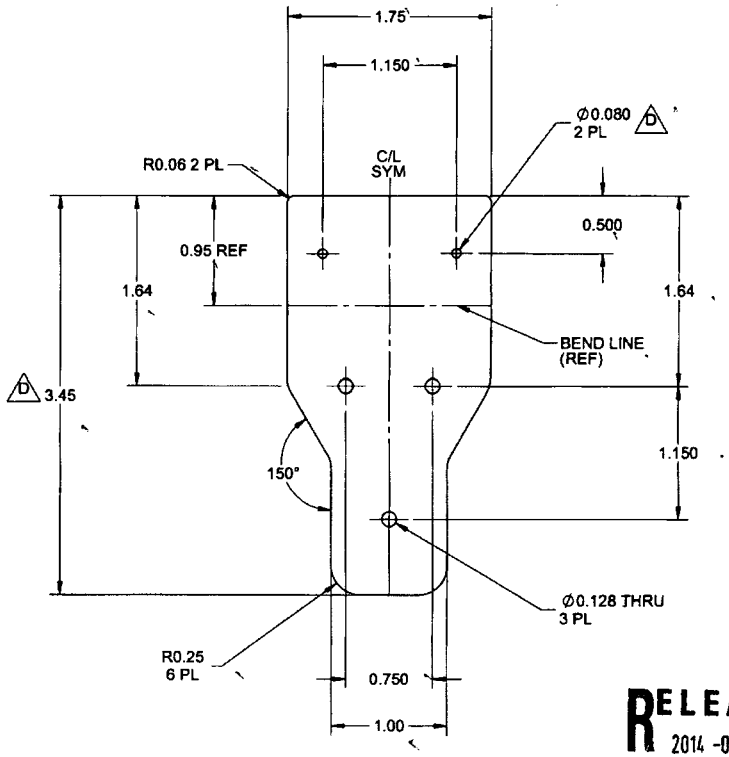
PO Instructions: quotation:
no: pec st-0670569

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explaination.

Change Nbr: 2 **Change Date:** 4/10/2014



D2267-1 L BRACKET



D2267-1F FLAT PATTERN

RELEASED
2014 -08- 27

REV.	DESCRIPTION	BY	DATE
D	AISI 304 SS WAS 2024-T3 ALUM., 1.00 WAS 0.75, 3.45 WAS 3.194, Ø0.08 2 PL WAS Ø0.128	DB	14.03.11
C	R0.13 WAS R0.094; ADDED FLAT PATTERN	RF	01.06.14
B	REDRAWN	RF	95.06.04
A	NEW ISSUE	RF	94.09.15

DESIGN	DB	DART AEROSPACE LTD
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	DRAWING NO. D2267 — REV. D
MFG. APPR.	JLM	SHEET 1 OF 1
APPROVED	MP	TITLE L BRACKET — SCALE NTS
DE APPR.	DS	
DATE	14.03.11	

APPROVED

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NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 16 GAUGE 0.063" THICK, (REF DART SPEC M304S16GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.09 lbs